

**Work Order ID 116585**

Monday, April 21, 2014 11:11:19 AM

**\*116585\***

Page 1

Item ID: D350-636-111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate Installation

Start Date: 4/21/2014 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 4/25/2014 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MF Date: 14-4-22

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9662	A

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo M.L.P.

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile &amp; type labels per PPP D350-636-111 CHG001

DAS  
31  
9-896x 14-04-25  
MTS 14-04-23

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

6x DAS 28  
9-89 APR 22 2014

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
31  
9-896x 14-04-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 116585**

Monday, April 21, 2014 11:11:20 AM

**\*116585\***

Page 2

Item ID: D350-636-111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate Installation

Start Date: 4/21/2014 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 4/25/2014 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D350-636-111

Location: SHIP6x 14-04-25 SL

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

14-4-2514-4-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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# Picklist Print

Page 1

Monday, April 21, 2014 11:11:09 AM

Work Order ID: 116585

\*116585\*

Parent Item: D350-636-111

\*D350-636-111\*

Parent Item Name: Wearplate Installation

Start Date: 4/21/2014

Required Date: 4/25/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.04.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status															
D4923-041		Manufactured	No				Each	0.0000	4 24																			
<div><div>*D4923-041*</div><div>DAS</div><div>31</div><div>9-89</div></div>																												
Wearplate Assembly									** 20x116170			DAS	33															
D4933-041		Manufactured	No				Each	0.0000	2 12			9-89																
<div><div>*D4933-041*</div><div>DAS</div><div>31</div><div>9-89</div></div>																												
Wearplate Assembly									** B 116171			DAS	28															
D4934-041		Manufactured	No				Each	0.0000	2 12			9-89																
<div><div>*D4934-041*</div><div>DAS</div><div>31</div><div>9-89</div></div>																												
Blade Assembly									** 116594			DAS	33															
AN3C5A		Purchased	No				Each	459.0000	24 144			9-89																
<div><div>*AN3C5A*</div><div>DAS</div><div>28</div><div>9-89</div></div>																												
Bolt									** 24 144			DAS	28															
<div><div>*AN3C5A*</div><div>DAS</div><div>28</div><div>9-89</div></div>																												
APR 22 2014																												
<div><div>*AN3C5A*</div><div>DAS</div><div>28</div><div>9-89</div></div>																												
<table><thead><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr></thead><tbody><tr><td>FG</td><td>5</td><td></td></tr><tr><td>122800</td><td>5</td><td></td></tr><tr><td>ST350</td><td>454</td><td></td></tr><tr><td>M128057</td><td>454</td><td></td></tr></tbody></table>														Location	Loc Qty	Loc Code	FG	5		122800	5		ST350	454		M128057	454	
Location	Loc Qty	Loc Code																										
FG	5																											
122800	5																											
ST350	454																											
M128057	454																											
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APR 22 2014

DAS  
31  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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REFERENCE ONLY

DAS  
31  
9-89

14-04-25

**DART SERVICE INSTRUCTION**TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. J  
AND INSTRUCTIONS FOR CONTINUING AIRWORTHINESS ICA-D350-636 REV. 3REF. FAA STC: SR00646SE  
REF. CANADIAN STC: SH99-7  
REF. EASA STC: 10033942**1.0 PURPOSE:**

The purpose of this service instruction is to introduce the D350-636-111 Wearplate Kit. The D350-636-111 Wearplate Kit replaces elements of the D350-636-011/-012/-013/-014 Skidtubes and elements of the D350-636-041/-043/-045 Wearshoe Kit and is designed to improve grip on low friction surfaces such as ice. The components in the D350-636-111 Wearplate Kit are defined in the parts list in Section 2.0.

**2.0 PARTS LIST**

ITEM	QTY	Part Number	Description
	<del>111</del>		
	X	D350-636-111	WEARPLATE KIT
1	4	D4923-041	WEARPLATE ASSY
2	2	D4933-041	WEARPLATE ASSY
3	2	D4934-041	BLADE ASSY
4	24	AN3C5A	BOLT
5	24	AN960C10L	WASHER

**3.0 WEIGHT AND BALANCE**

The following is the net weight increases associated with the D350-636-111 Kit

Installation	Weight	LONGITUDINAL		LATERAL (STD GEAR)		LATERAL (HIGH GEAR)	
		Arm	Moment	Arm	Moment	Arm	Moment
D350-636-111 WEARPLATE KIT	3.82 lb 1.74 kg	132.1 in 3.4 m	504.6 in-lb 5.9 m-k	0	0	0	0

**4.0 INSTALLATION OF D350-636-111 WEARPLATE KIT**

- 4.1 Refer to Figure 1 on sheet 2 of this Service Instruction. Remove and retain the components indicated per ICA-D350-636, Sections 32.3 and 32.4. Ensure the AN8 fasteners are serviceable.
- 4.2 Refer to Figure 2 on sheet 2 of this service instruction. Install the D4934-041 Blade Assy. Torque the AN8C21A bolts to 480-690 in-lbs (54.2-78.0 N-m).
- 4.3 Refer to Figure 2 on sheet 2. Install the D4923-041 Wearplate Assy and the D4933-041 Wearplate Assy as shown. Torque the AN3C5A bolts to 15-25 in-lbs (1.7-2.8 N-m).
- 4.4 Repeat this procedure for the other Skidtube.
- 4.5 Adjust Weight and Balance per Section 3.0 of this Service Instruction.

DESIGN

DB

**DART AEROSPACE USA, INC.**

DRAWN

DB

KENT, WA

CHECKED

ASS

DRAWING NO.

REV. A

MFG. APPR.

N/A

WEARPLATE INSTALLATION

SHEET 1 OF 2

APPROVED

160

TITLE

SCALE

DE APPR.

-H

DSI 9662

NTS

DATE

13.09.11

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